

Date: Tuesday, 27/01/2009 11:11:20 AM  
User: Julie Dawson

Process Sheet

Dart Aerospace Ltd.

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 45271  
Estimate Number : 11403  
P.O. Number :  
This Issue : 27/01/2009 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : SMALL /MED FAB  
Previous Run : 43294  
Written By :  
Checked & Approved By : JLD 09-01-27  
Comment : Est. C 05.10.14 Added step 14 KJ/EC  
Est Rev:D Revised Steps 06-11-20 JLM

Drawing Name : DOOR ASSEMBLY  
Part Number : D3296041  
Drawing Number : D3296 REV A  
Project Number : N/A  
Drawing Revision : A  
Material :  
Due Date : 10/02/2009 Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32961 Door Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-1	Door Panel	<u>42030</u>

FF 09/02/02

(6)

2.0 D32963 Door Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-3 Door Panel		<u>42037</u>

FF 09/02/02

(6)

3.0 D31617 Hinge 14.0"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hinge 14"

Batch: 43607 x 4 / 45323 x 2

FF 09/02/02

(6)

4.0 D31619 Hinge 17.0"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hinge 17"

Batch: 43314

FF 09/02/02

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 27/01/2009 11:11:20 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 45271

Part Number: D3296041

Job Number:



Seq. #: Machine Or Operation: Description:

5.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total: 100.0000 Each(s)

Rivet, Universal Head

Batch: M109631 ~~109631~~

FF 09/02/02

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Fabricate & assemble as per Dwg D3296.

FF 09/02/02

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/05 (x6)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 9:00

OVEN TEMPERATURE: 320°

FINISH TIME: 9:30

MD / FX

09/02/06

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 09-02-06

(x6)

10.0 D2137 Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~4.0000~~ 6.000 Each(s)

Decal - No Step

Pick:

Qty Part Number Description Batch

1 D2137 Decal B43594

FF 09/02/00

11.0 D2419 Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~4.0000~~ 6.000 Each(s)

Handle

Pick:

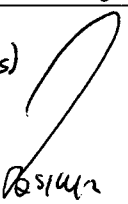

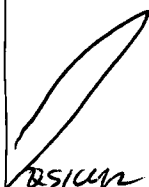
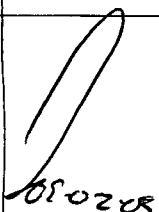
Qty Part Number Description Batch

1 D2419 Handle B43549 X4 \*B 45639 X2

FF 09/02/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3296-041 PAR #: NA Fault Category: Prod / Process NCR: Yes No DQA Date: 09/02/12  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/02/13

NCR: <u>45271</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/02	6	3 Holes in EACH Hinge drilled in wrong position (0.141 Holes) Human Error. RC: Lack of Attention		scraped + Replaced <del>with</del> D31617 #110267 (6x) Qty 6 scrapped & destroy MS 2025 737 200.	FF 09/02/02			

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 11:11:20 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 45271

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2462

Seal



Comment: Qty.: 0.3333 f(s)/Unit Total: ~~1.3333~~ 1.9998 f(s)

Qty Part Number Description Batch

1 D2462 Seal B37747

CUT ONE PIECE 4.00" LONG

FF 09/02/10

(6)

13.0

D2462

Seal



Comment: Qty.: 0.4420 f(s)/Unit Total: ~~1.7680~~ 2.652 f(s)

Qty Part Number Description Batch

1 D2462 Seal B37747

CUT ONE PIECE 5.30" LONG

FF 09/02/10

(6)

14.0

D2462

Seal



Comment: Qty.: 2.0420 f(s)/Unit Total: ~~8.1680~~ 12.252 f(s)

Qty Part Number Description Batch

1 D2462 Seal B37747

CUT ONE PIECE 24.50" LONG

FF 09/02/10

(6)

15.0

D27281

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal B39012

FF 09/02/10

(6)

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~4.0000~~ 6.000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer m6085

FF 09/02/10

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 45271

Part Number: D3296041

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 MS20470AD46 Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~4.0000~~ Each(s)  
Rivet, Universal Head  
Pick: 6.0000

Pick:

Qty Part Number Description Batch  
1 MS20470AD4-6 Rivet

1109371

FF 09/02/10

(6)

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D3296

FF 09/02/10

(6)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/10 (X6)

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

ST217

09/02/10 (6)

21.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/12

Job Completion



MF 09-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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04.07.12 ~~11~~



- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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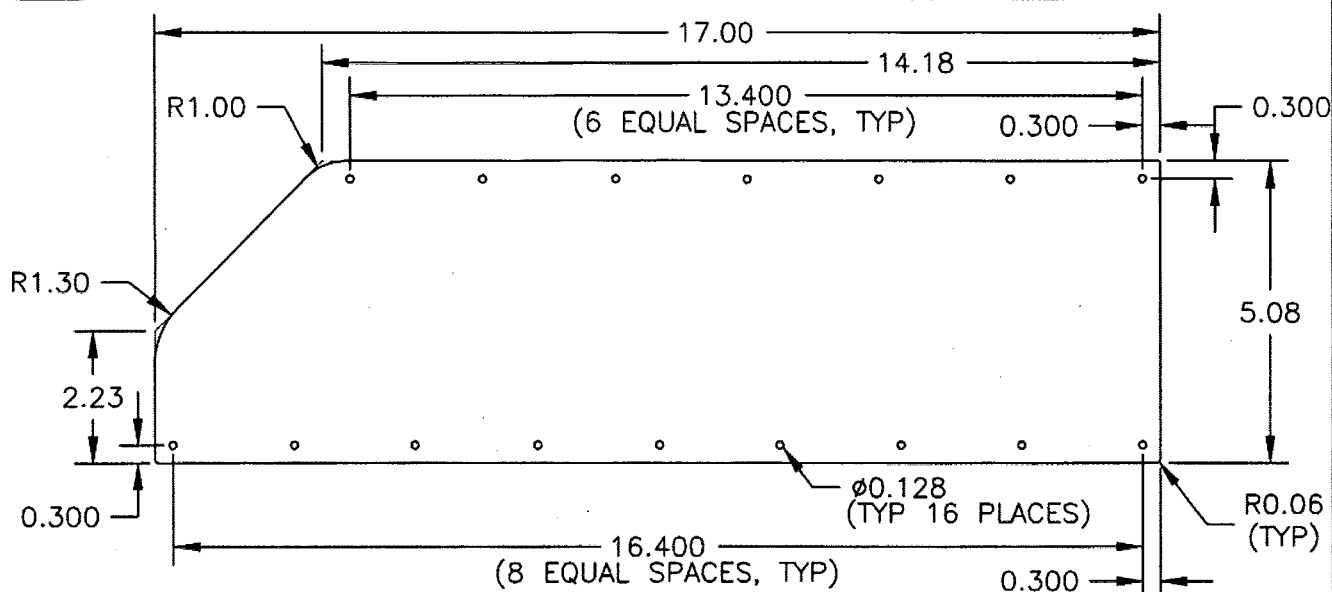
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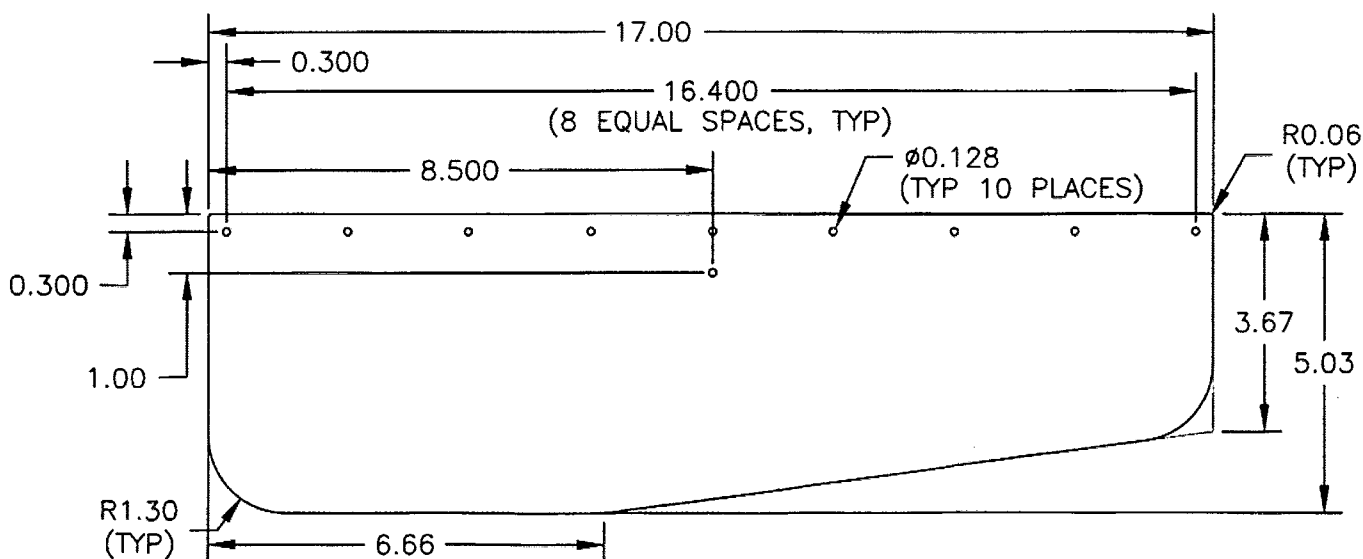
WORK ORDER  
15271-  
ID



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



**D3296-1 DOOR PANEL**



**D3296-3 DOOR PANEL**

**D3296-1 AND D3296-3**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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